0.00

Memo

OC

Quality Control

NCR:	Yes	/	No

DQA: \_\_\_\_\_Date: \_\_\_\_

NCR:	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
									•		QA Closed:	Date:	**
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N						Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo.					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root			-		Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data													
quip/Tooling													
perator													
/laterial													
etup													
Other													
rocess													
upplier													
raining													
Inapproved							- 0 / 11	T CATE	CORV				1
Landii						General	-AUI	LT CATE	GURY				
Lanuii		Bending				Bend	_	Grain			Ovalized	Г	Pressure/Forced
		Centre No	t Cancar	atric to 1	\(\sigma_1\)	BOM/Route	-	Hardwa	**	-	Over/Under	talaransa	Temperature/Cure
		Cracks	it Concer	itile to	<sup>3</sup> /3  -	Broken/Damaged	$\vdash$	-i	on Incomplete	-	Part Incorred		Weld
		Crushed/0	^rimned		<u> </u>	Burrs	$\vdash$	<b>⊣</b> `	ions Incomplete	/Unclear	Part Lost/Mi	<del></del>	Wrong Stock Pulled
		Cuffs	ompeu.		-	Contamination	$\vdash$	Mainte	•	- Officieal	Part Moved	331116	
ł		Heat Trea	t		<u> </u>	Countersink	-	Mislabe		<u> </u>	Positioned V	/rong	
Inspection Strip in Tube Cut Too Short							Misread		<u> </u>	Power Loss/	_	Other	
Ripples in Bend Drill Holes Offset							L	J. 5115, 2000,		1-200			
ľ		Torque W		xtrusio	,   <del>-</del>	Drawing		-1	Calibration				
		Turning Se			-	Finish		4	Sequence			· · ·	
	Wave/Tw		e		Folio		-1	Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Quality Control

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	100	NFORI	MANCE / UPI	DATE	OA Classal.	Data	7.
			<del></del>					-				QA Closed:	Date:	
Nork Ord	er:						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
							Rework	]		Skid-tube	Crosstube		Water Jet	Engineering
Part	Vo.						Scrap	]		Machining	Small Fab		d. Eng. Coor.	Quality
							Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR	No.						Work Order Update	J		Large Fab	Composite	]	Supplier	
Root					Des	crip	otion of work order update	tion	Sign &					
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	_	Bending					Bend	<u> </u>	Grain		_	Ovalized	<u> </u>	Pressure/Forced
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	Cuffs Contamination							$\vdash$	Mainte		<u> </u>	Part Moved		
									Mislabe		<u> </u>	Positioned V		٦ -
	Inspection Strip in Tube Cut Too Short Misread							d		Power Loss/	Surge	Other		
	L	Ripples in					Drill Holes		Offset					
:		1			n ]		Drawing	Out of Calibration						
		Turning So	Torque Waves in Extrusion Drawing Out of Calibration  Turning Sequence Finish Out of Sequence											

Outside Dimensions

Wave/Twist in Tube

Folio

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Quality Control

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	100	VFORM	MANCE / UP	PDATE			
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							Rework	]		Skid-tube	Crosstube	7	Water Jet	Engineering
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NCR	No.						Work Order Update	]		Large Fab	Composite	]	Supplier	
			Description of modern Law 1 with 1 Assistance											
Root		_			Des	-	otion of work order update	1	nitial		ction	Sign &		
Cause		Date	Step	Qty		C	or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
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Land	ng (	Gear					General							
		Bending					Bend	Г	Grain		`	Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to C	o/s		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
									Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped Burrs								Instruct	ions Incomplete,	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs Contamination Ma								Mainte	nance		Part Moved		_
		Heat Trea	t				Countersink		Mislabe	led		Positioned V	Vrong	-
	L	Inspection	n Strip in	Tube			Cut Too Short		Misread	I		Power Loss/	Surge	Other
•	L	Ripples in	Bend				Drill Holes		Offset					
		Torque W	aves in E	xtrusion	1		Drawing		Out of 0	Calibration				
	l	Turning Se	equence				Finish	1	Out of S	equence				

Outside Dimensions

Wave/Twist in Tube

Folio

Work Orde October-31-12				*925	522*							Page 4	
Revision ID:	647.1613 Doubler			Accept	*N900	<b>040</b>	100	)* s	Setup S	Start Stop	ı V.	S1* S2*	
Start Date: Required Date: Reference:	10/31/12 11/09/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:							
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:		J		Start Stop	I ZI I	R1* R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp	_
*100* SprayPaint Spray Painting				0.00 CLASS N AS PER DWG.	(SEE NOTE 3)				0	<u></u>	<u>Ø</u>	12-12-15	•
200		CARDINAL  QC14- Inspect Spray Pai	, 4860-50 PRIMER BA	0.00								. 1	
*200* QC Quality Control		Memo		0.00								0AS 05 13	-19
<sup>210</sup> * <b>21</b> 0*		Identify as per dwg & St	ock Location:/35/	0.00						1 2 / 1	/_	//	
Packaging		Memo		0.00				/		<u> </u>	1_7		

\*\*\*IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV\*\*\*

Packaging

NCR:	Yes	1	Nο	

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
				-						QA Closed:	Date:	
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
					Rework	]		Skid-tube	Crosstube	_	Water Jet	Engineering
Part N	0			<del></del>	Scrap	4 1		Machining	Small Fab	4	d. Eng. Coor.	Quality
NCR N					Use-as-is	4		noforming	Finishing	Rec/Stor	re/Packaging	Other
NCK N	··				Work Order Update	╛┃		Large Fab	Composite	]	Supplier	J LJ
Root				Descr	iption of work order update	In	itial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector
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quip/Tooling						ļ						
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rocess												
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. [	Bending				Bend		Grain			Ovalized		Pressure/Forced
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	Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorred	ct	Weld
	Crushed/	Crimped.			Burrs	l 🔲	nstruct	ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs Contamination						Mainte	nance	:	Part Moved		1
Heat Treat Countersink							Mislabe	led		Positioned V	Vrong	
Inspection Strip in Tube Cut Too Short							Misread	l		Power Loss/		Other
Ripples in Bend Drill Holes							Offset		<b>L</b>	<b>.</b>	-	
ſ	Torque W	/aves in E	xtrusio	,	Drawing	П	Out of C	Calibration				
Ţ	Turning S	equence			Finish	П	Out of S	equence				
	Wave/Tw	ist in Tub	e	<u> </u>	Folio	Outside Dimensions						

DQA: Date:

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Work Orde				*925				Page 5				
Revision ID:	647.1613 Doubler			Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	ı vı .	S1* S2*
Start Date: Required Date: Reference:	10/31/12 11/09/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:	Process Pl	lan:	Date:	Tooling: SPC (Y/N):	Date: Date:				Run	Start Stop	17	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	ject y	Reject Number	Insp. Stamp
*220 *220*		QC21- Final Inspection -	Work Order Release	0.00						131	1/10	$\mathcal{A}$
QC Quality Control		Memo		0.00						M	5 13	3-04-0

NCR:	Yes	1	Nο

NCR: Y	′es	/ No				WORK ORDER NON-0	CONF	ORN	/ANCE / UP	DATE	DQA:		•
At a value O value						DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Work Orde Part N NCR N	10.				· · · ·	Rework Scrap Use-as-is Work Order Update Skid-tube Machining Machining Small Fab Thermoforming Large Fab Composite Scription of work order update Scription of work order update					Pro	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Init	ial	Ac	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator flaterial etup ther rocess upplier raining													
						F	AULT C	ATE	GORY				
Landir	Landing Gear  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence			General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Ha Ins Ins Mi Mi Of	structi ainte islabel isread fset it of C	on Incomplete ions Incomplete/ nance led	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
ţ	_	Wave/Tw				Folio	<del></del>		Dimensions				

## **Picklist Print**

\*October-31-12 11:29:27 AM

Work Order ID:

Parent Item Name:

92522

Parent Item:

647.1613

Doubler

**Start Date:** 10/31/12

Start Qty: 1.00

Required Date: 11/09/12

Required Qty: 1.00

Comments:

IPP REV:A 12.10.04 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050 2024-T3 .050 sheet		Purchased	No			110	sf	178.0484	0.0487	0.0512632 O· (			JM 12-11-1
				Location		Loc Qty	Lo	c Code					
				MAT022		178.0484204							
				1176	584	17.8							
				1212	216	45.6484204							
				1218	889	114.6			121	1999			

				-								DQA:	D	ate:	•
NCR: Y	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE		QA Closed:		ate:	*
								Í				-		ate.	
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Part N	- No			_		Rework Scrap	]	•	Skid-tube Machining	Crosstube Small Fab	_	Pro	Water Je	$\vdash$	Engineering Quality
1	•0. –				<del></del>	Use-as-is	-		noforming	Finishing		4	re/Packaging	-	Other
NCR N	No				<del></del>	Work Order Update	]	1	Large Fab	Composite			Supplie	$\vdash$	
Root					Descr	iption of work order update	Τ	Initial	Ac	tion	_	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cł	nief Eng	Desc	ription		Date	Verification	on	QC Inspector
Doc/Data	Ш									•					
Equip/Tooling															
Operator															
Material															
Setup	Ш					•						_			
Other															
Process				] ,											
Supplier															
Training															
Unapproved						***	$\perp$								
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Landir	ng G	ear				General	_	_				-		_	
	Щ	Bending				Bend	L	Grain				Ovalized			Pressure/Forced
	Ц́	Centre No	t Concer	ntric to	D/S	BOM/Route	L	Hardwa	re		<u> </u>	Over/Under	tolerance		Temperature/Cure
	Щ́	Cracks				Broken/Damaged		Inspecti	on Incomplete		_	Part Incorre	ct		Weld
	Ц°	Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/	'Unclear		Part Lost/M	issing		Wrong Stock Pulled
		Cuffs				Contamination	Г	Mainte	nance			Part Moved			_

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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DART AEROSPACE LTD	Work Order: 92522		
Description: Volker	Part Number: 647, 1613		
Inspection Dwg: 647.1600 Rev: 10/c	Page 1 of 1		

# FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6,104"	+0.004"-0,001"	0.106"	- '		U .	Produjoz
A 10A"	+0.005 -0.001"	6.182	-		υ	
0.196"	10005 0.001	0.197			V	
1,24"	11-0,010"	1,24"		:	<u> </u>	•
0.40"	11-0.010	0.405	_		N	
2.83"	41-0.018	2.632			ن	
0.294"	A-0005"	0.299	_		V	
6.344"	H-0,005'	0.345			V	
0.688"	11-0.005	0.689	<u> </u>		₹ V	
1.071"	4-0.005"	1,066"	<u> </u>		/	
6.4000	the 0.005	0.403				
G, 600'	11-0.005"	6.601"			V	
1,240	11-0.015	1,24"	-		V	
2.48"	H-01010"	2.483	-		V	
0.050	H-0.000	0.047"			V	
			54. 34. 52.0			
		<u> </u>				
,				-1		
· .						
		*		<u> </u>		
	· .					
						· w·

Measured by:	Audited by: 15	Preliminary Approval:
Date: (2-11-18	Date: 10-11-10	Date:

Rev	Date	Change	<u> </u>		Revised by	Approved
E	10.04.14	Added preliminary	approval	1,3-33.7	KJ	

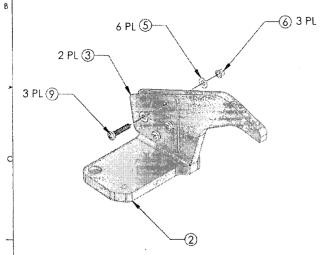
A 10.04.15

A MATERIAL: ALUMINUM 7075-T651 AMS-QQ-A-250/12

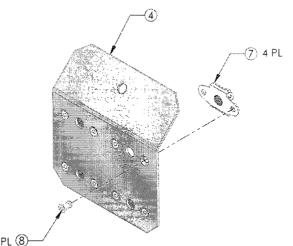
MATERIAL: ALUMINUM 2024-T3 PER AMS QQ-A 250/4

FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL P 23377 J TYPE I CLASS N

- 4. DEBURR AND BREAK ALL SHARP EDGES.
- 5 IDENTIFY IAW MPP-120



647.1601 SHOWN EXPLODED

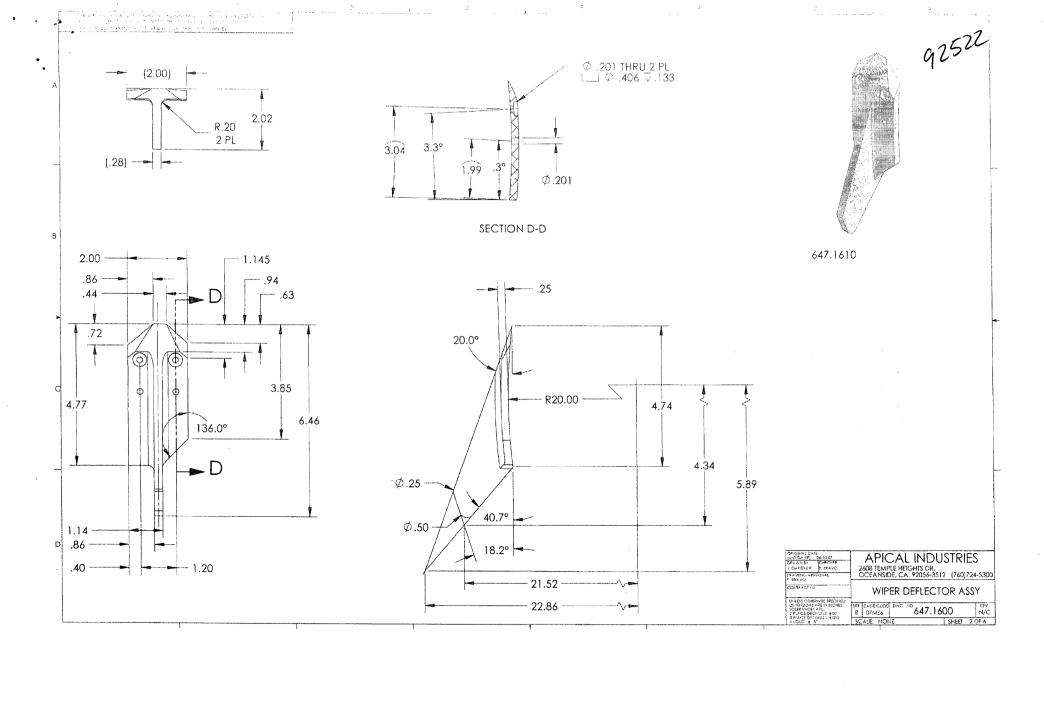


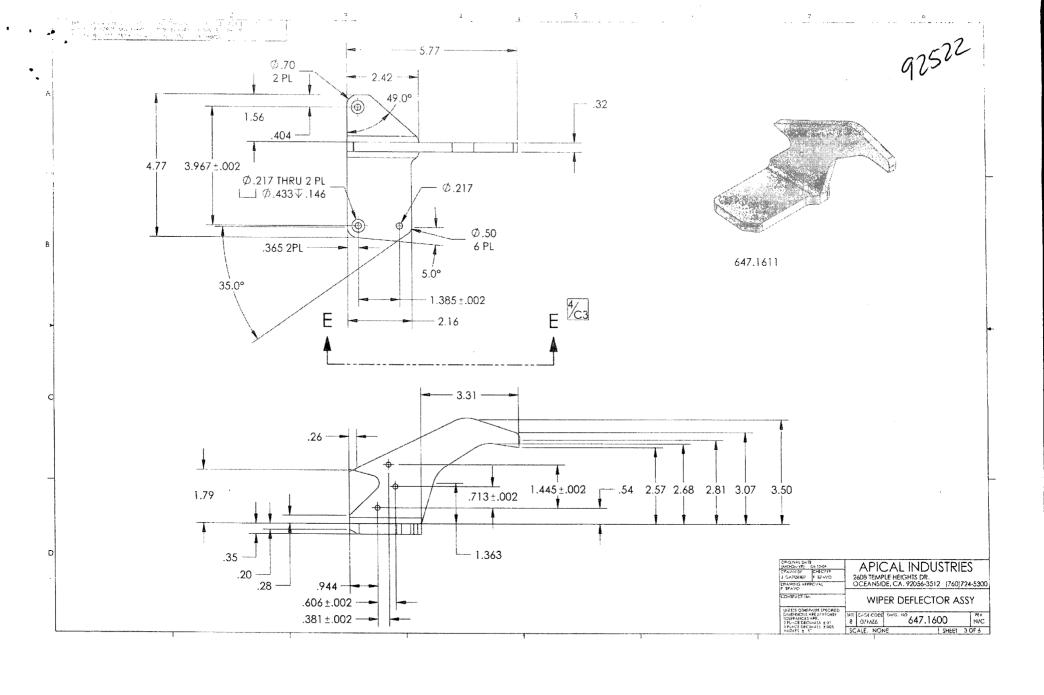
647,1602 SHOWN EXPLODED

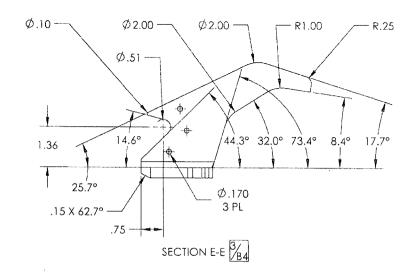
SHOPCOPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 92522 ML3
12-11-01

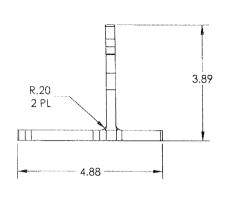
QTY		l#	FARIF	PARTS LIST	MALL	SPEC.
1602	.1501	FIND	PART#	DESCRIPTION	MATL	SPEC
	Χ		647,1601	WIPER DEFLECTOR ASSY, AFT		
Χ			647.1602	DOUBLER ASSY		
		1	647.1610	WIPER DEFLECTOR, FWD		<u>/3</u> \
	1	2	647.1611	WIPER DEFLECTOR, AFT	<u> </u>	<u>[3]</u>
	2	3	647.1612	SPLICE PLATE		<u> </u>
1		4	647.1613	DOUBLER	(2)	<u>(3)</u>
	6	5	601.2764	WASHER	MAS) 14554832F	
	3	6	601.2973	LOCKNUT	M\$01540-08	
4		7	601.1900	NUTPLATE	AS21059-3	
а		8	601,2980	NUTPLATE RIVET	C/CR264SS-0-04	
	3	9	601.2989	SCREW	AS27039-0612	

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA., 92056-3512 (760)724-5300 NEXT ASSY [S] 647,1300 WIPER DEFLECTOR ASSY B 07M26 647.1600





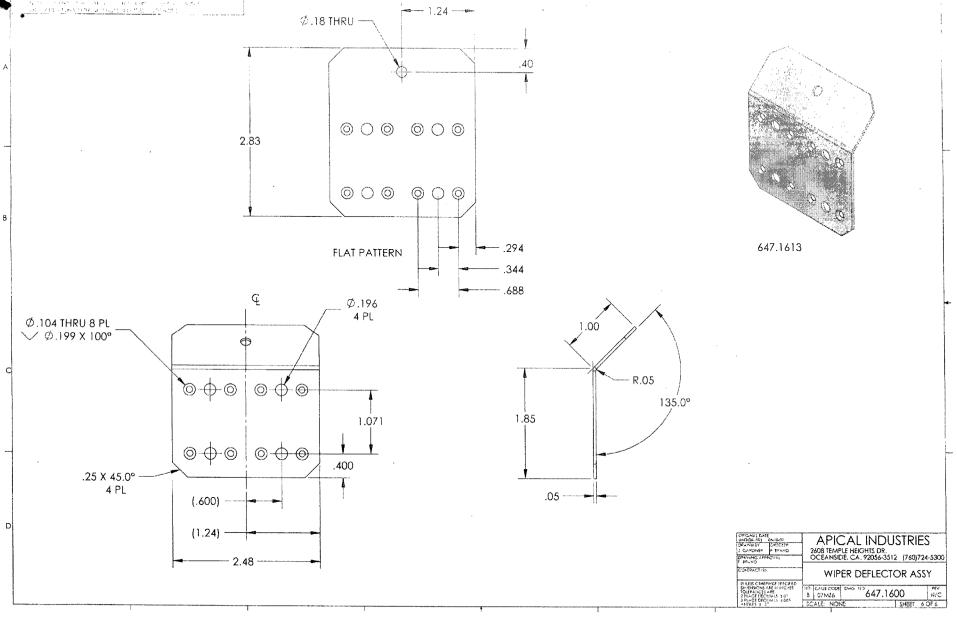




	••	ES
		724-5300
WIPER	DEFLECTOR A	SSY
12E CAGE CODE 156 8 07MZ6	647.1600	REV N/C
	2608 TEMPLE OCEANSIDE. WIPER	

- 2.03 <del>-</del>

| SET | CAGE COOK | DWG | NO | 647.1600 | N/C | | SCALE: NONE | SHEET 50F6





A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

### Pack List

Number: 62076

Date: 27-Nov-12

То

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Quantity Description    1	FII. 013-032-320		Shin Via			
1 Part: ASST Rev:  4 PCS D4410-11 2 PCS 647.1612 14 PCS.647.1812 11 PCS 647.1810 2 PCS 647.1811 8 PCS 647.1815 10 PCS 647.1815 10 PCS 646.3110 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120737 PO: PO18399 Line:  Certificate of Conformance  A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.  ISO 9001: 2008 REGISTERED ATG SALES-2010 TERMS APPLY  DATE: 27/11/12  CERTIFIED SIGNATURE:	Terms		Ship Via			
1 Part: ASST Rev:  4 PCS D4410-11 2 PCS 647.1612 14 PCS.647.1812 11 PCS 647.1810 2 PCS 647.1811 8 PCS 647.1815 10 PCS 647.1815 10 PCS 646.3110 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120737 PO: PO18399 Line:  Certificate of Conformance  A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.  ISO 9001: 2008 REGISTERED ATG SALES-2010 TERMS APPLY  DATE: 27/11/12  CERTIFIED SIGNATURE:						
1 Part: ASST Rev:  4 PCS D4410-11 2 PCS 647.1612 14 PCS.647.1812 11 PCS 647.1810 2 PCS 647.1811 8 PCS 647.1815 10 PCS 647.1815 10 PCS 646.3110 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120737 PO: PO18399 Line:  Certificate of Conformance  A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.  ISO 9001: 2008 REGISTERED ATG SALES-2010 TERMS APPLY  DATE: 27/11/12  CERTIFIED SIGNATURE:	Quantity	Description				
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2 PCS 647.1811 8 PCS 647.1814 11 PCS 647.1815 10 PCS 646.3110  HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120737  PO: PO18399  Line:  Certificate of Conformance  A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.  ISO 9001: 2008 REGISTERED ATG SALES-2010 TERMS APPLY  DATE: 27/11/12  CERTIFIED SIGNATURE:	<	11 PCS 647.1013				
8 PCS 647.1814 11 PCS 647.1815 10 PCS 646.3110  HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120737 PO: PO18399 Line:  Certificate of Conformance  A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.  ISO 9001: 2008 REGISTERED ATG SALES-2010 TERMS APPLY  DATE: 27/11/12  CERTIFIED SIGNATURE:	ì					
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MIL-A-8625 TYPE III CLASS 2 Job: 20120737 PO: PO18399 Line:  Certificate of Conformance  A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.  ISO 9001: 2008 REGISTERED ATG SALES-2010 TERMS APPLY  DATE: 17/11/12  CERTIFIED SIGNATURE:		HARD ANODIZE BLACK				
Job: 20120737  PO: PO18399  Line:  Certificate of Conformance  A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.  ISO 9001: 2008 REGISTERED ATG SALES-2010 TERMS APPLY  DATE: 47/11/11/2  CERTIFIED SIGNATURE:		MIL-A-8625 TYPE III CLASS 2				
A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.  ISO 9001: 2008 REGISTERED ATG SALES-2010 TERMS APPLY  DATE: 17/11/12  CERTIFIED SIGNATURE:			PO: PO18399	Line:		
with all requirements, specifications and drawings referenced in the purchase drawings.  ISO 9001 : 2008 REGISTERED  ATG SALES-2010 TERMS APPLY  DATE : 17/11/12  CERTIFIED SIGNATURE :		Certificate of Co	nformance			
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